



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D3144-15
Job Sheet 199619



Part No: D3144-15

Job Qty: 4 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 9/27/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 13294

Note: DWG REV C IPP A 05.11.03 New issue KJ/RF IPP Rev:B 07-10-23 Now on Water JET JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		9/27/19	0.17	0.49	Waterjet - Flow	9/28/19	JRB
120	QC 8	4 pcs		9/27/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Handfinish - 1-1 Chemical- B4B	4 pcs		9/27/19	0.00	0.26	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		

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Container No: S218081

Part: D3144 - 15

Job No: 199619

Serial No/Batch: S218081

Revision:

Inspector:

Exp Date:

Date: 09/28/19

Instructions: Various STC's

				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	Powdercoat - 4 Black Sand - B4B	4 pcs	9/27/19	0.00 0.06	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
150	QC 3	4 pcs	9/27/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
160	Packaging 3-1 - Stock - B4B	4 pcs	9/27/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B

M 138910
 START: 10:35 O.T: 300° FINISH: 1:05

BL 19-10-01

DAS
 61
 9-89

DAS
74
9-89

OCT 02 2019

Packaging 3 - 4 - B4B
Packaging 3 - 5 - B4B
Packaging 3 - 6 - B4B
Packaging 3 - 7 - B4B
Packaging 3 - 8 - B4B
Packaging 3 - 9 - B4B
Packaging 3 - 10 - B4B
Packaging 3 - 11 - B4B
Packaging 3 - 12 - B4B
Packaging 3 - 13 - B4B
Packaging 3 - 14 - B4B
Packaging 3 - 15 - B4B
Packaging 3 - 16 - B4B
Packaging 3 - 17 - B4B
Packaging 3 - 18 - B4B
Packaging 3 - 19 - B4B
Packaging 3 - 20 - B4B
Packaging 3 - 21 - B4B
Packaging 3 - 22 - B4B
Packaging 3 - 23 - B4B
Packaging 3 - 24 - B4B
Packaging 3 - 25 - B4B
Packaging 3 - 26 - B4B

170 QC 21 - SA 4 9/27/19 0.00 0.00
pcs

QC 21 - SA - 21
QC 21 - SA - 70
QC 21 - SA - 53

DAS
21
9-89

OCT 02 2019

Part Op 100 - 1-Cut as per Dwg D3144 Dwg Rev: C Prog Rev: C 2-Deburr if necessary
Descriptions: 120 - QC8- Inspect parts - second check
130 - Chemical Conversion Coat per QSI005 4.1
140 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
FINISH TIME: _____
150 - QC3- Inspect Part Finish
160 - (Identify as per dwg & Stock Location: _____) Location : CA2
170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	1.3200 sf (.33 ea)	100-Waterjet - Flow - 1	5018261

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.032	1	164	0

Part Specifications

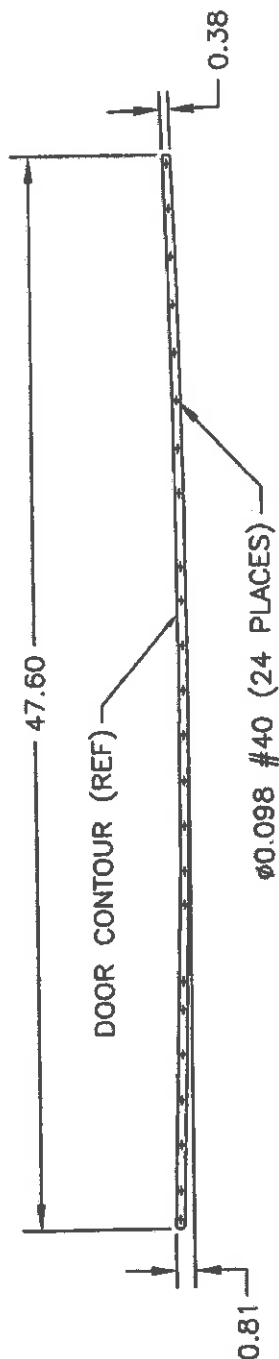
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.098inches + 0.004 - 0.001	0.102 0.097	0.099	
2	Doubler	0.380inches ± 0.030	0.410 0.350	0.380	
3	Doubler	47.600inches ± 0.030	47.630 47.570	47.600	
4	Doubler	0.032inches ± 0.010	0.042 0.022	0.032	



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3144	REV. C SHEET 4 OF 9
DATE 05.10.19	TITLE DOUBLER		SCALE NTS

RELEASED

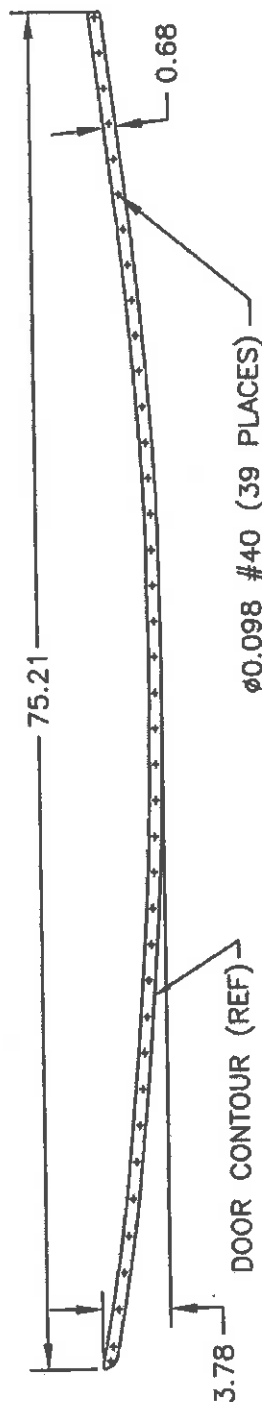
05-11-14



D3144-15 DOUBLER
SCALE 1:8

D3144-15 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"



D3144-13 DOUBLER
SCALE 1:10

REPLACES PREMIER P/N B30-23000-211

D3144-13 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.020 THICK (REF DART SPEC M2024T3S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"

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